

Date: Thursday, 20/11/2008 3:35:35 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 43630		Part Number	: D32343		
Estimate Number	: 13550		Drawing Number	: D3234 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 20/11/2008 S.O. No. :		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 28/11/2008 Qty: 4 Um: Each		
Previous Run	: 41252					
Written By	:					
Checked & Approved By	: JUL 08.11.24					
Comment	: Est Rev:A New Issue 08-08-14 JLM Verified By:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
		 
		<b>Comment:</b> Qty.: 0.2273 sf(s)/Unit Total : 0.9093 sf(s) 2024-T3 .050 sheet BATCH: 107711 <b>B8-11-24</b>
2.0	WATER JET	FLOW WATER JET
		 
		<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3234 Dwg Rev: <b>A</b> <b>B8-11-24</b> Prog Rev: <b>A</b> 
		2-Deburr if necessary <b>B8-11-24</b>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 
		<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 
		<b>Comment:</b> SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		 
		<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1
		 <b>08/11/25</b>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 43630

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



8/4/25



(5x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



SK

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 237

8/11/25

SO

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/26 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43630
Description: Doubler	Part Number:	D3234-3
Inspection Dwg: D3234	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

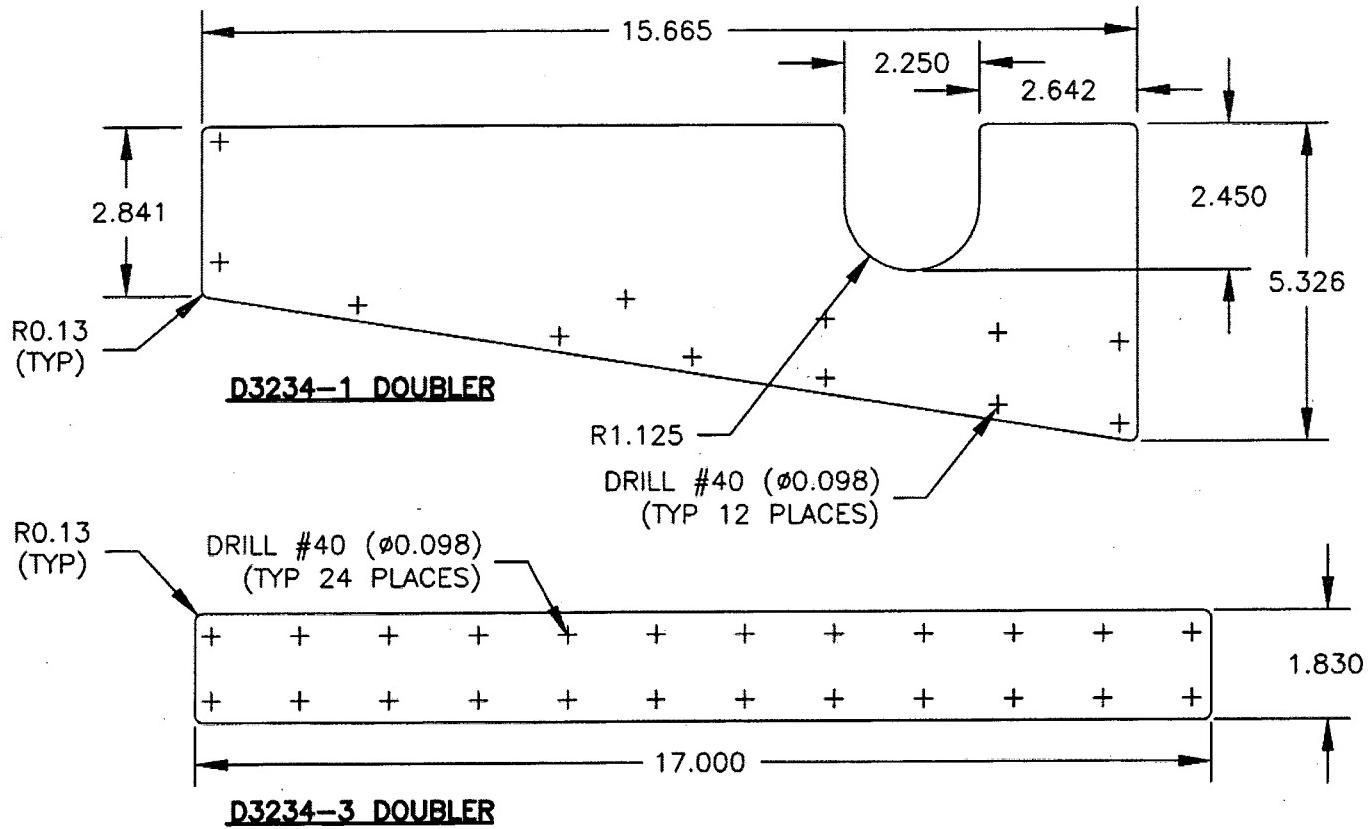
Measured by:	B	Audited by:	C	Prototype Approval:	N/A
Date:	8-11-54	Date:	08/11/25	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	08.09.04	New Issue	KJ/DD	DD

**DART**DRAFT COPY IS  
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3234 REV. A SHEET 1 OF 1
DATE 03.11.19		TITLE DOUBLER SCALE 1:3

A 03.11.19 NEW ISSUE

**RELEASED**03.11.24 *fff***D3234-1/-3 DOUBLER, D3234-5 SPACER**

- 1) MACHINE PARTS PER DWG FILE "D3234-A.DWG"
- 2) MATERIAL: -1/-3: 2024-T3 (QQ-A-250/4), 0.050 THICK (REF DART SPEC. M2024T3S.050)  
-5: 5052-H32 (QQ-A-250/8), 0.050 THICK (REF DART SPEC. M5052H32S.050)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

NO. 13630  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER